

Date: Thursday, 4/20/2006 9:53:48 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT(-013)
Job Number	: 23104		
Estimate Number	: 10563		
P.O. Number	: NIA	Part Number	: D205596107
This Issue	: 4/20/2006 S.O. No. : NIA	Drawing Number	: D205596107
Prsht Rev.	: NC	Project Number	: NIA
First Issue	: 11/15/2005 Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 23103	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/14/2006
Checked & Approved By	: <u>2</u>	Qty:	1 Um: Each
Comment	: Est Rev:D 05.03.21 Added bending procedure KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

DP 05.05.03 ①

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

B22534

DP 06-4-20

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend D2890 as per Dwg D2890 and Folio FT002

DP 06-4-20

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06.05.05 ①

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Deburr and Polish

Pmc 06-05-10 ①

56. Re 210 Line RT 06-04-19 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:53:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT. X-TUBE EXT HEIGHT(-013)

Job Number: 23104

Part Number: D205596107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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pm 06-05-260

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP06-5-31

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP06-5-31

9.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

DP06-5-31

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

DP06-5-31

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

DP06-5-31

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP06-5-31

13.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

mm 06 07 24
mm 06 07 25

01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:53:49 AM
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Job Number: 23104

Part Number: D205596107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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14.0	QC14	Inspect Spray Paint
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Comment: Inspect Spray Paint

06-07-27 ①

15.0	D2856600	Abrasion Strip
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Comment: Qty.: 1.6810 f(s)/Unit Total : 1.6810 f(s)

Pick:

Qty	Part number	Description	Batch
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2	D2856-600(10.09")	Abrasion Strip	B24328
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RT 06-07-31

16.0	D29401	Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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2	D2940-1	Support	
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B25594 RT 06-07-31

17.0	MS2192028	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
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4	MS21920-28	Clamp	
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M100479 RT 06-07-31

18.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg 205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

A/R Sikaflex -291

Expiry date:

RT 06-08-01
Permanent Change

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06-08-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 06/08/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 23104

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location: _____

PPP Rev: C

21.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



C206108102

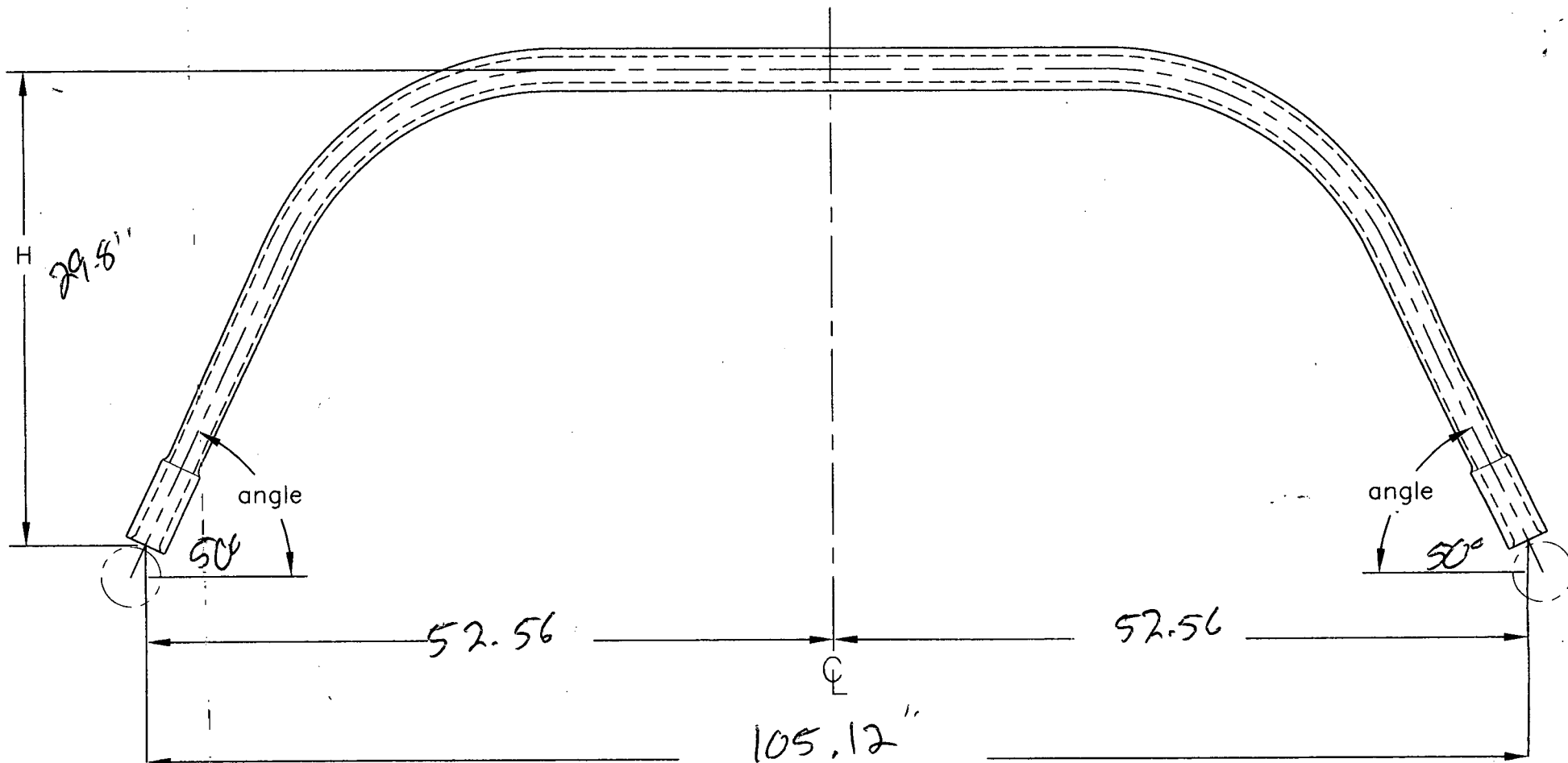
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DATE: 06-05-05
 DESCRIPTION: D205-596-107
 BATCH NO: 23104
 DRAWING: D205-596-107
 H: 29.8'
 1/2 SPAN: 52.5"
 TOTAL SPAN: 105.0"
 ANGLE: 50°

18
 060505